

Work Order ID 131885

Tuesday, April 21, 2015 2:08:36 PM

131885

Page 1

Item ID: D2204-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rubber Latches
 Start Date: 4/20/15 Start Qty: ~~10.00~~ ²⁰ ***10*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: ~~10.00~~ ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2204	Rev B

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O 28231 Make per Dwg D2204 Possible supplier: Accurate
 Rubber P/N: 286750017 Material release note required

CZ APR 23 2015 20

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

20X SP15-04-27

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

20 38 9-89

APR 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 131885***131885***

Page 2

Item ID: D2204-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rubber Latches

Start Date: 4/20/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr sharp edges of steel brackets

20X

DAS

28

9-89

APR 28 2015

140

140

Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

M131545.

Memo

0.00

Powder Coating

START TIME:

9:20

OVEN TEMPERATURE:

FINISH TIME:

9:50.

20 ϕ 15-4-29 8:30

150

150

QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

(20)

DAS

38

9-89

APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Page 3

Tuesday, April 21, 2015 2:08:36 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST 488A</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

2015

APR 30 2015

MLJ

ME
15-4-30

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Tuesday, April 21, 2015 2:08:35 PM

13188.5

D2204-9

Start Date: 4/20/15**Required Date:** 4/20/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP E02.06.11 Added finishRF

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐					

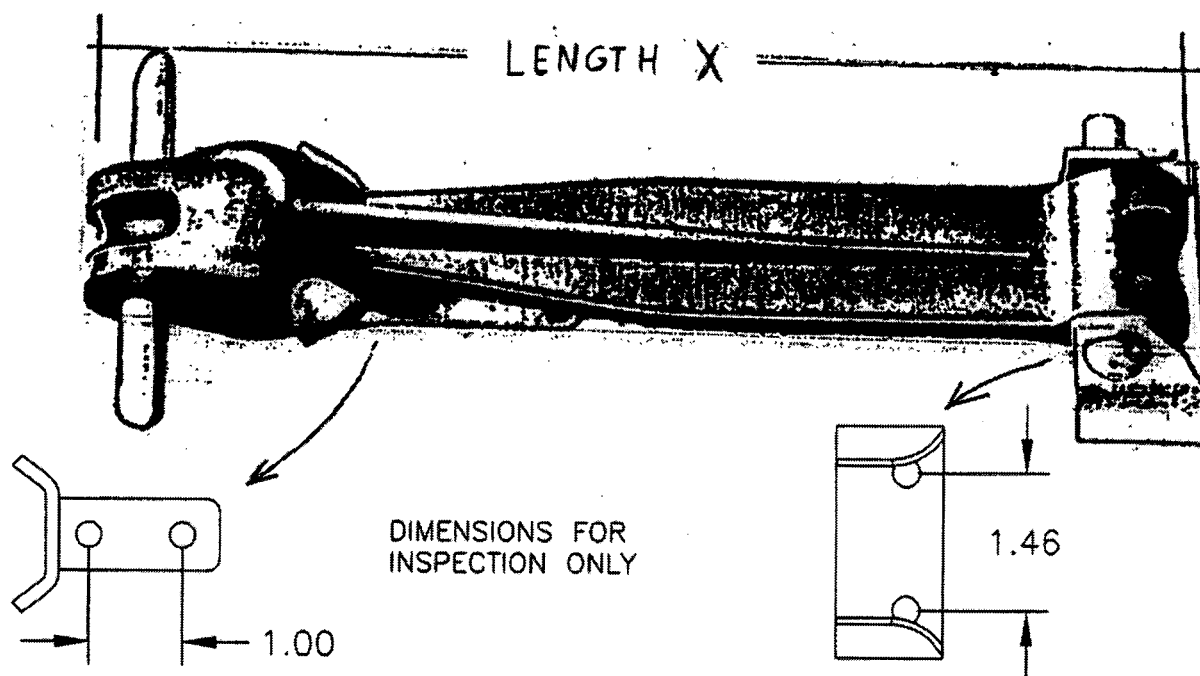


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>KE</i>	DRAWING NO. D2204	REV. B SHEET 1 OF 1
DATE 98.12.15		TITLE LATCH, RUBBER	SCALE NTS
A	93.11.15	NEW ISSUE	
B	98.12.15	UPDATED PICTURE, ADD VENDOR P/N	

RELEASED
48.12.16 *KE*

UNDER REVIEW
OK # 01.05.17

SPECIFICATION CONTROL DRAWING



D2204-X RUBBER LATCH WITH BRACKETS

LENGTH

EG: 9" LONG: D2204-9
5" LONG: D2204-5

POSSIBLE SUPPLIERS:
ACCURATE RUBBER,

P/N 286750017 FOR 9" LATCH ASSEMBLY
P/N 286750010 FOR 9" RUBBER ONLY

NO. 131885 MJS
1504-22
COPY
SERIALS
SECTION
DATE
BY



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28231

Purchase Order Date 4/23/2015 7:50:46 AM
PO Print Date 4/23/2015

Page Number 1 of 2

Order From :
ACR GROUP INC.
12771 - NO. 5 ROAD
RICHMOND, BC V7A 4E9
CA

VC-ACR001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 604 274 9955

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	286-750-017	Rubber Latch	4/29/2015 Yes 4/29/2015		20.00 ✓ Each	\$17.00	\$340.00

AS PER DWGH D2204 REV. B
B131885

SP15-04-27

Line Total:

\$340.00

PO Instructions: Fedex Acc#151793240

Note:

4/23/2015



12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9

PACKING SLIP

CUSTOMER COPY

Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

PACKING SLIP 00153898

CUSTOMER NO. 10750

www.acrgroup.ca

PST#

S DART AEROSPACE LTD
O 1270 ABERDEEN STREET
L HAWKESBURY, ON K6A 1K7
T Canada
O

S DART AEROSPACE LTD
H 1270 ABERDEEN STREET
P HAWKESBURY, ON K6A 1K7
T Canada
O

DATE		SHIP VIA		TERMS	
04/24/15		FED EX O/N		ACR GROUP INC. NET 30 DAYS	
PURCHASE ORDER NUMBER		DATE ORDERED		SALES PERSON	
P028231		04/23/15		00153898 ROB	
QUANTITY		ITEM NUMBER		DESCRIPTION	
ORDERED	SHIPPED	B.O.		UNIT	UNIT PRICE
10	10	-	286750017	9" HOOD HOOKS - COMPLETE SET	EA
10	10	-	286750017	9" HOOD HOOKS - COMPLETE SET	EA
<i>Spis out 10/27</i> <i>13#</i>					
				SUBTOTAL	
				HST	
FREIGHT: Collect				TOTAL AMOUNT	

Quality Rubber Products To Your Requirements
Specialists in Bonding Natural and Synthetic Rubber To Metal
Molded and Extruded Rubber Products, Cast Polyurethane Specialties